

Date: Wednesday, 13/08/2008 10:09:17 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: HEAD REST	
Job Number	: 41188 -2					<i>Split</i>	
Estimate Number	: 10738						
P.O. Number	:				Part Number	: D3303041	
This Issue	: 13/08/2008 S.O. No. :				Drawing Number	: D3303 REV.B	
Prsht Rev.	: NC				Project Number	: N/A	
First Issue	: / / Type : SMALL /MED FAB				Drawing Revision	: B	
Previous Run	: 40859				Material	:	
Written By	:				Due Date	: 29/08/2008	
Checked & Approved By	: <u>JUL 08.8.13</u>				Qty:	16 Um: Each	
Comment	: Est: B 04.10.05 Revised Step 5 with headrest identification K J/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D3303043	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) BRACKET ASSEMBLY	
		Pick: Qty Part Number Description Batch	 4099
1	D3303-043	Bracket Assembly	8/8/08 50
2.0	D330501	Cushion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) FOAM CUSHION	
		Pick: Qty Part Number Description Batch	 B40909
1	D3305-1	Cushion	50 8/09/18 (8)
3.0	D3306041	Cover Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) COVER ASSEMBLY	
		Pick: Qty Part Number Description Batch	 B38970
1	D3306-041	Cover Assembly	8/8/08 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:09:17 AM
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Drawing Name: HEAD REST

Job Number: 41188

Part Number: D3303041

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/1300L adhesive. Identify as D3303-041

A/R 3M 1300/1300L Adhesive Batch: M108 891

8608109110

SB08109110 (4)

EE 08/09/18 (4)

EG 08/09/18 (4)

2- Cover Head Rest with D3306-041 as per Dwg D3303

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a permanent fine point marker as per Dwg D3303, then Stock

Location: 129/18 (8)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/18 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.09.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

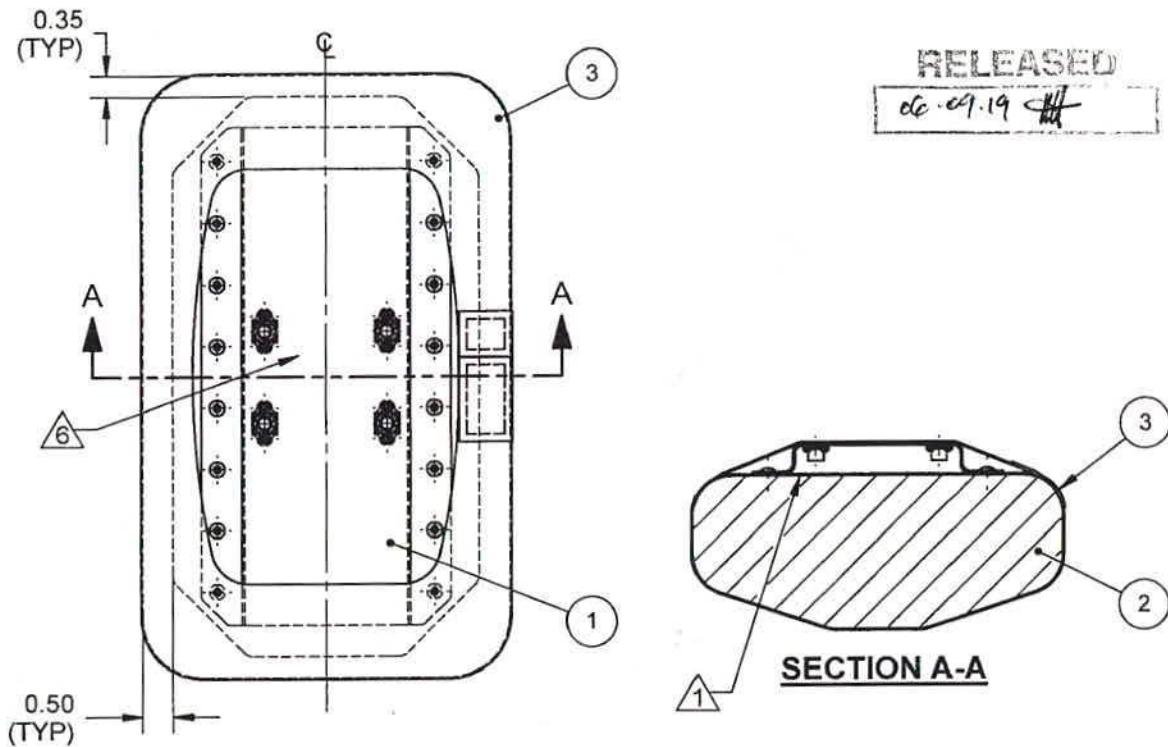
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PF</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>AB</i>	DRAWING NO. D3303	REV. B	SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE	1:3
REV A	DATE 04.08.18	DESCRIPTION NEW ISSUE		
REV B	DATE 06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE		

**D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

NOTES:

1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE

(0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN

3) PART IS SYMMETRICAL AT CENTERLINE

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:

"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT

ELIGIBILITY SEE PDA04-11"

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WORK ORDER

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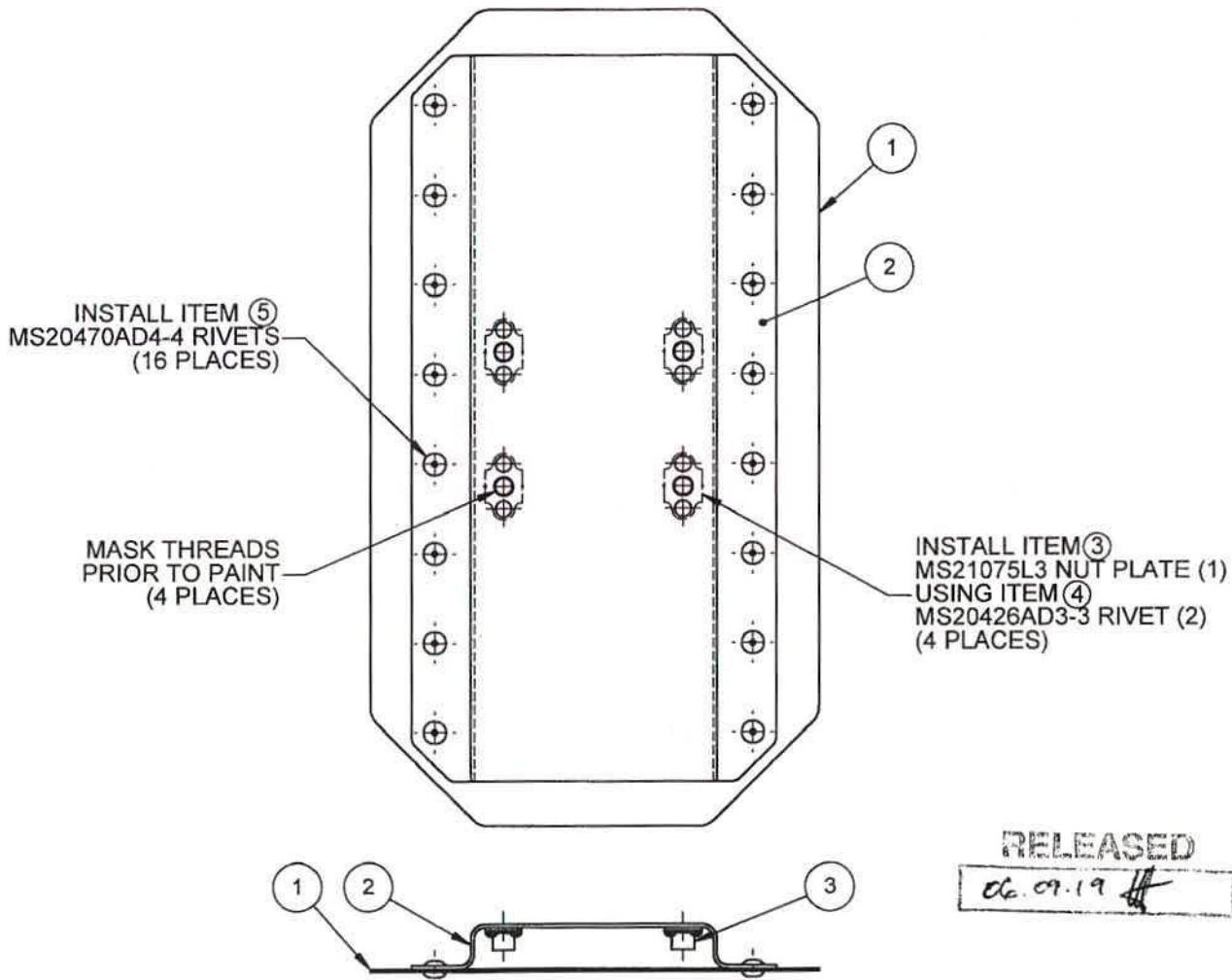
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2	

**D3303-043 BRACKET ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

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NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

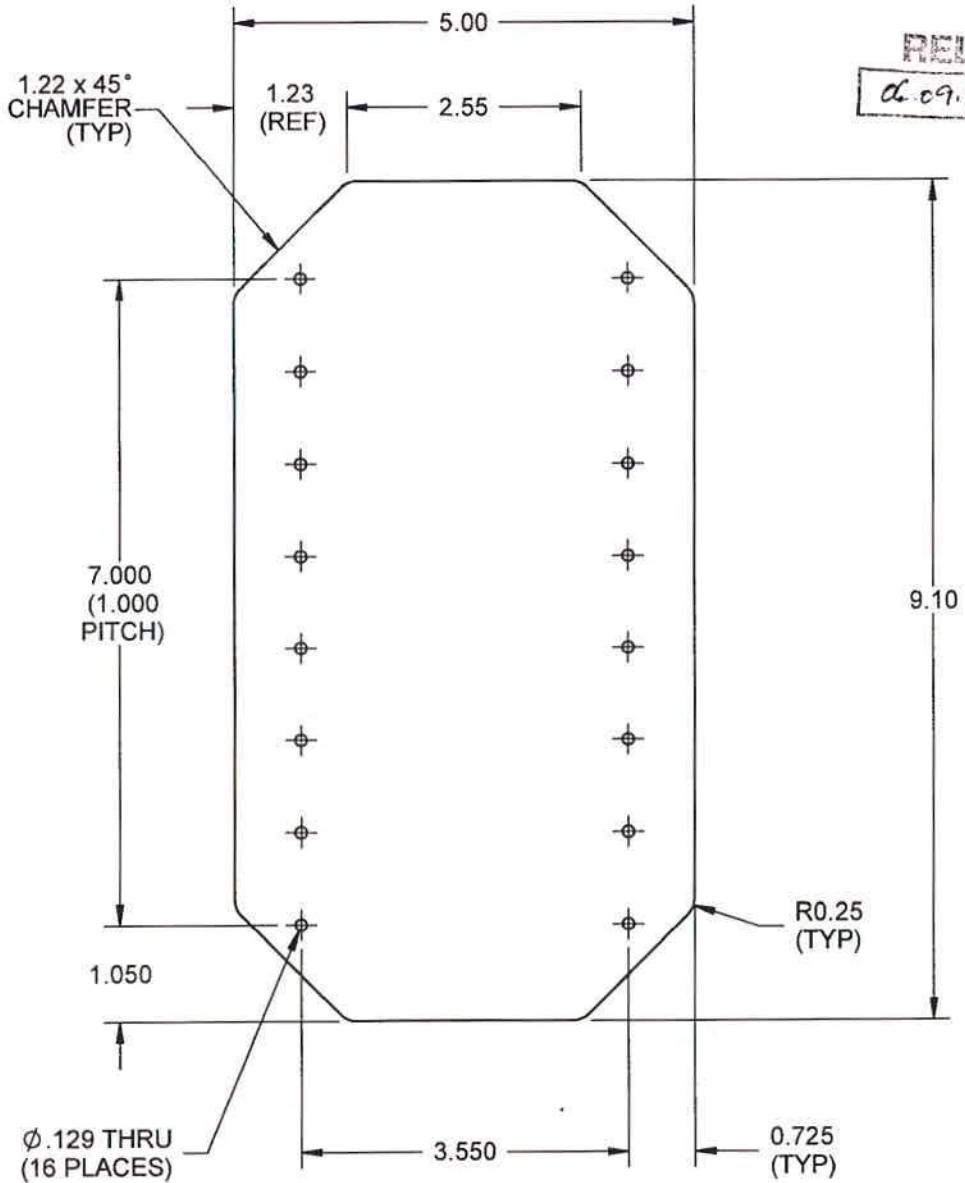
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 QA: N/C Closed: _____ Date: _____

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DART

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CHECKED <i>PH</i>	APPROVED <i>SH</i>	DRAWING NO. D3303	REV. B SHEET 3 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2	

**D3303-1 PLATE****NOTES:**

1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)

2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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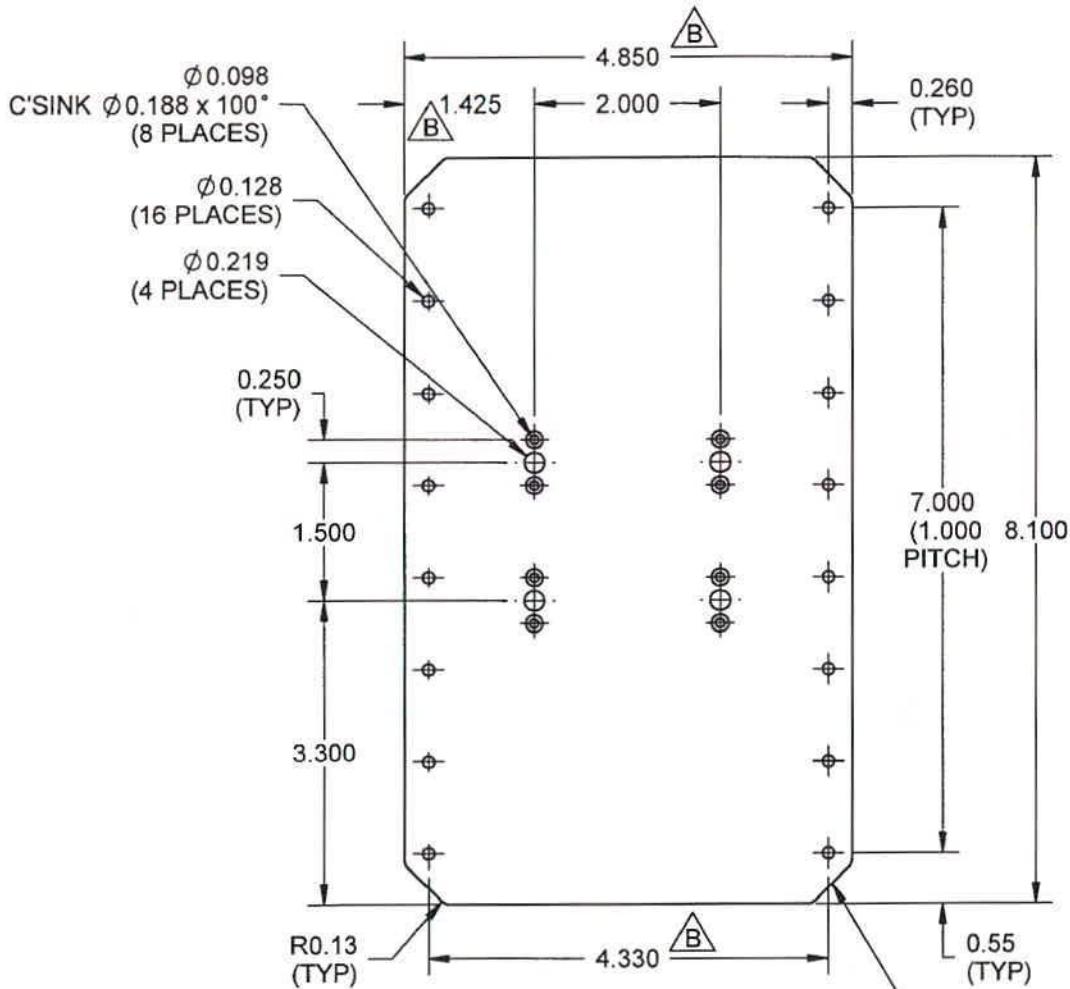
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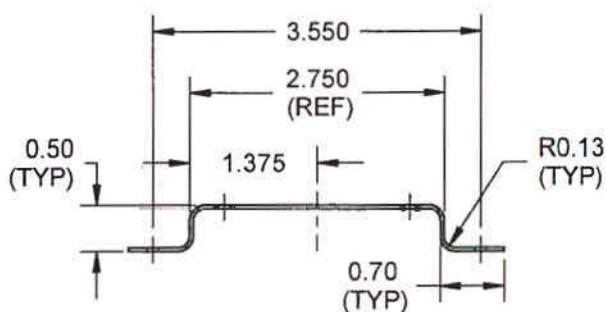
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CHECKED <i>PH</i>	APPROVED <i>HF</i>	DRAWING NO. D3303	REV. B SHEET 4 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**D3303-3F BRACKET FLAT PATTERN**

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**D3303-3 BRACKET BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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